

Work Order ID 65414

Monday, January 17, 2011 9:07:24 AM



Page 1

Item ID: D3656-1

Accept



Setup Start



Revision ID:

Item Name: PANEL

Stop



Start Date: 1/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-01-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3656

Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

x2

DL

11/01/18

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F

Time IN: 4:00 pm 11/01/17

Time OUT: 7:00 am 11/01/18

x2

DL

10/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 8986 <input type="checkbox"/> Dwg. Rev. <u>B</u> <input type="checkbox"/> Folio Rev. <u>C</u>	0.00 0.00				<u>x2</u>			<u>OK</u> <u>11/01/18</u>
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect for proper formation of each part	0.00 0.00				<u>x2</u>			<u>OK</u> <u>11/01/18</u>
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>x2</u>			<u>OK</u> <u>11/01/18</u>

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Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions as per dwg D3656	0.00 0.00							<i>DL</i> 11/01/18
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00							<i>DL</i> 11/01/18
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Sutcliffe</i>		<i>(42)</i>			

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Item Name: PANEL

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Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

P1165527

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-01-20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, January 17, 2011 9:07:19 AM

Page 1

Work Order ID: 65414



Parent Item: D3656-1



Parent Item Name: PANEL

Start Date: 1/18/2011

Required Date: 1/31/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 07/12/13 New issue DL verified by:DD
IPP Rev. B 08/09/25 Dwg. Update DL.
Add Sstep 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.093-F6006-07

Purchased

No

100

sf

1,613.990

32

64



GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

therm

1613.99

107574

6.46

112176

66.5667

114459

1540.9633

DL
11/01/18

64 sq ft.

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	65414
Description: Panel		Part Number:	D3656-1
Inspection Dwg: D3656	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: DL Date: 11/01/18

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070	Min	0.074	✓			
0.050	Min	0.053	✓			
24.7	REF	24.8"	✓			
0.7	REF	0.7"	✓			

Measured by: DL Date: 11/01/18
 Audited by: BB Date: 11/01/19
 Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	

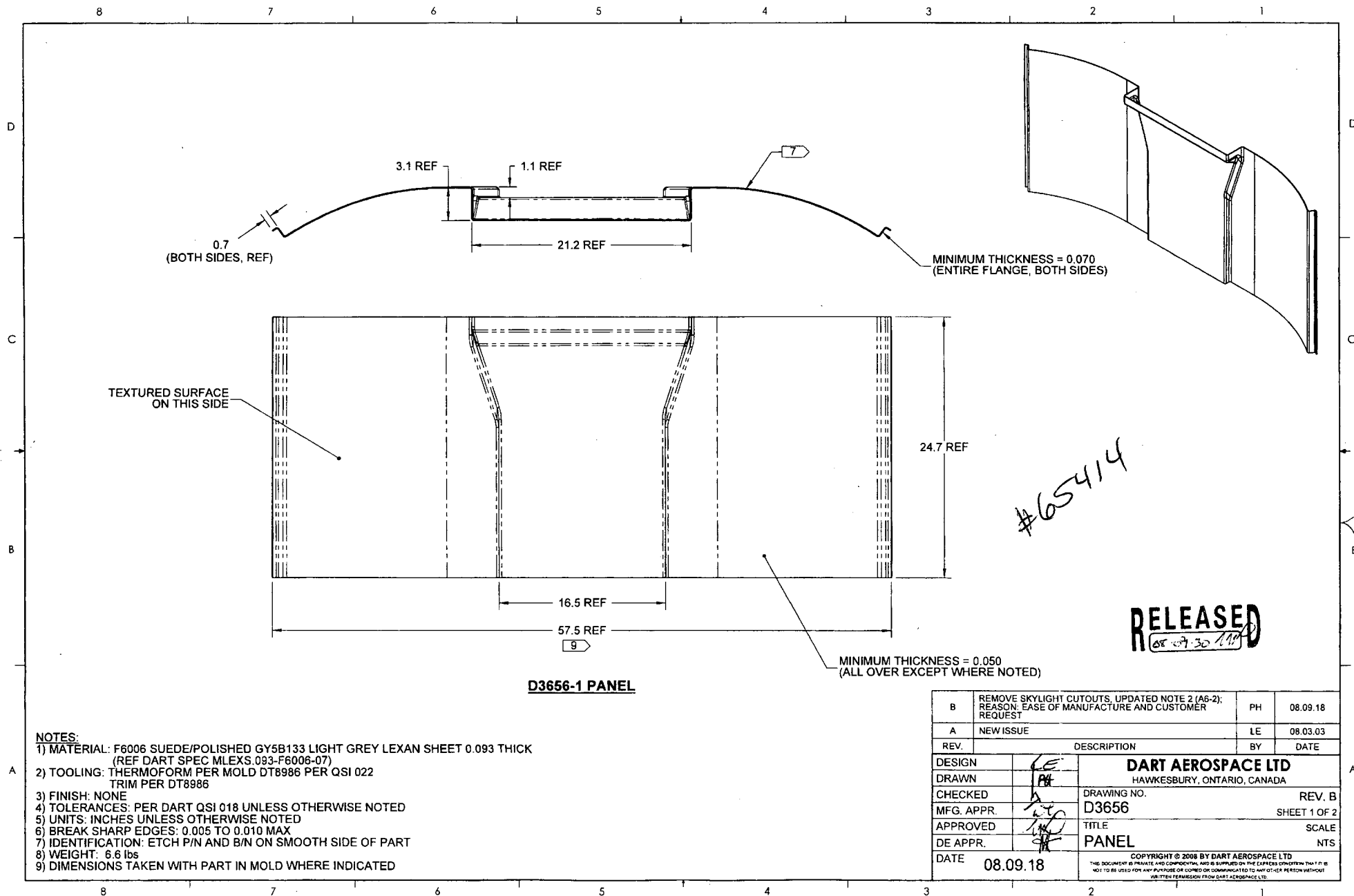
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RELEASED
08-09-30 11:00

B	REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2); REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST	PH	08.09.18
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3656	SHEET 1 OF 2
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	PANEL	NTS
DATE	08.09.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

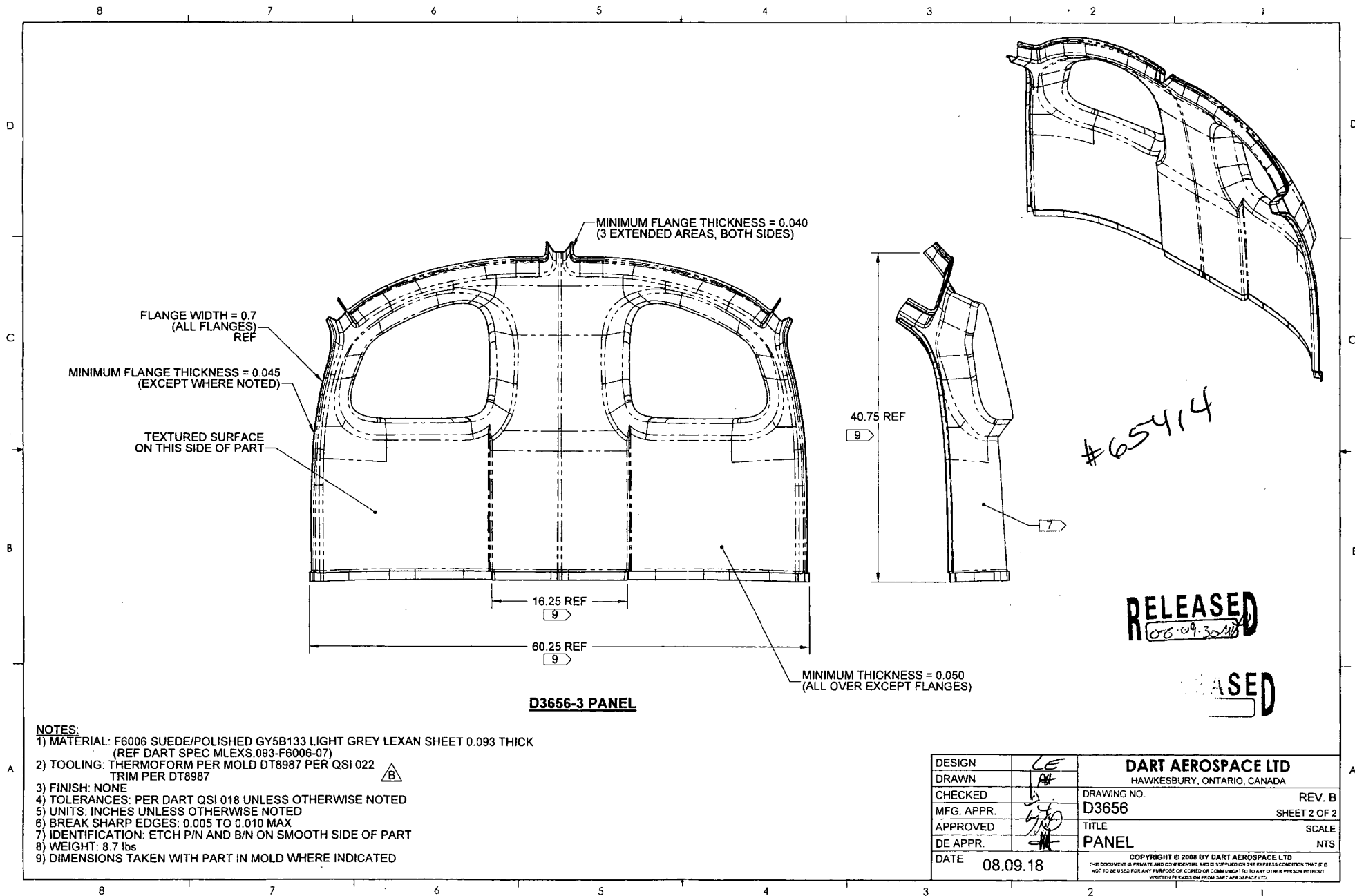
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